

Date: Tuesday, 9/4/2007 11:29:58 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE BRACKET
Job Number : 34407	
Estimate Number : 12254	
P.O. Number : <i>N/A</i>	Part Number : D34813
This Issue : 9/4/2007	Drawing Number : D3481REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : A
Previous Run : 28749	Material : <i>N/A</i>
	Due Date : 10/4/2007
Written By : <i>[Signature]</i>	Qty: 6 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: A New Issue 06-02-07 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

Cut as per Dwg D3481

Dwg Rev: *A*Prog Rev: *A**HB 07-09-06*

2.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.0515 sf(s)/Unit Total : 0.3087 sf(s)

304/316 0.018 SHEET

(m304s26ga)

Batch: *m 105490 HB 07-09-06**(P10)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*HB 07-09-06*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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*counts*

Comment: SECOND CHECK

HB 07-09-06 (46)

5.0	BRAKE NC	NC BRAKE
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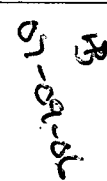
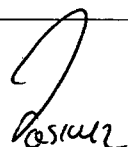



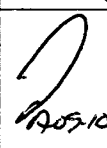
Comment: NC BRAKE

Form as per Dwg D3481

*HB 07-10-06 / 10**(P10)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/10	20	one part has a small blow out near the bend line Machine malfunction. P.C. scraped	 05/10/12	Scrap and destroy and replace	 07-09-10	Er 07/09/10	 05/10/12	Er 07/09/10
07/09/10	5	1 piece was out of tolerance	 05/10/12	Scrap destroy	SS 07/09/10	 07-09-10	 05/10/12	 07/09/10

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:29:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE BRACKET

Job Number: 34407

Part Number: D34813

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 08.2/10 (45) counts

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 07/09/11 (5)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/11

Job Completion



07/09/11

Dart Aerospace Ltd

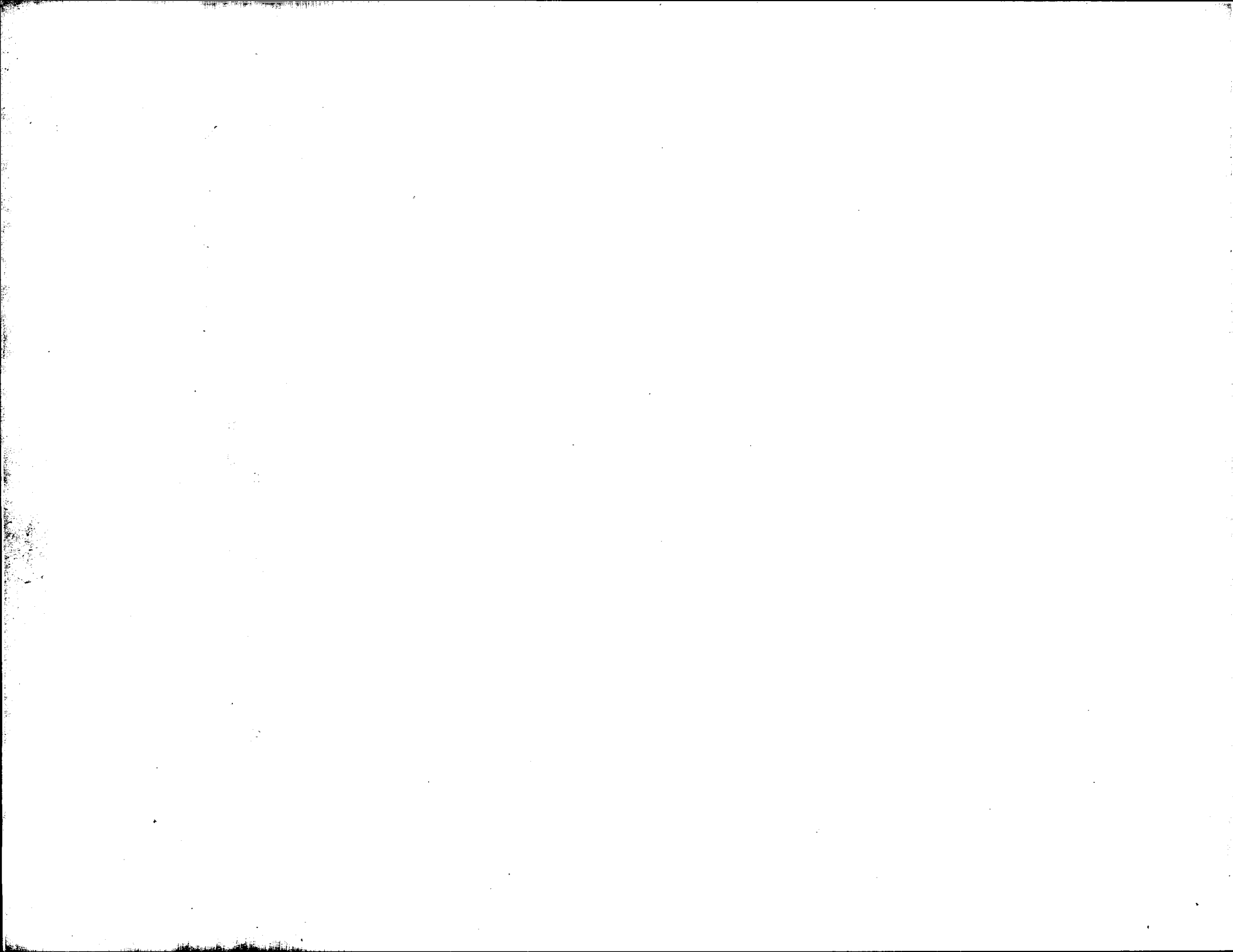
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

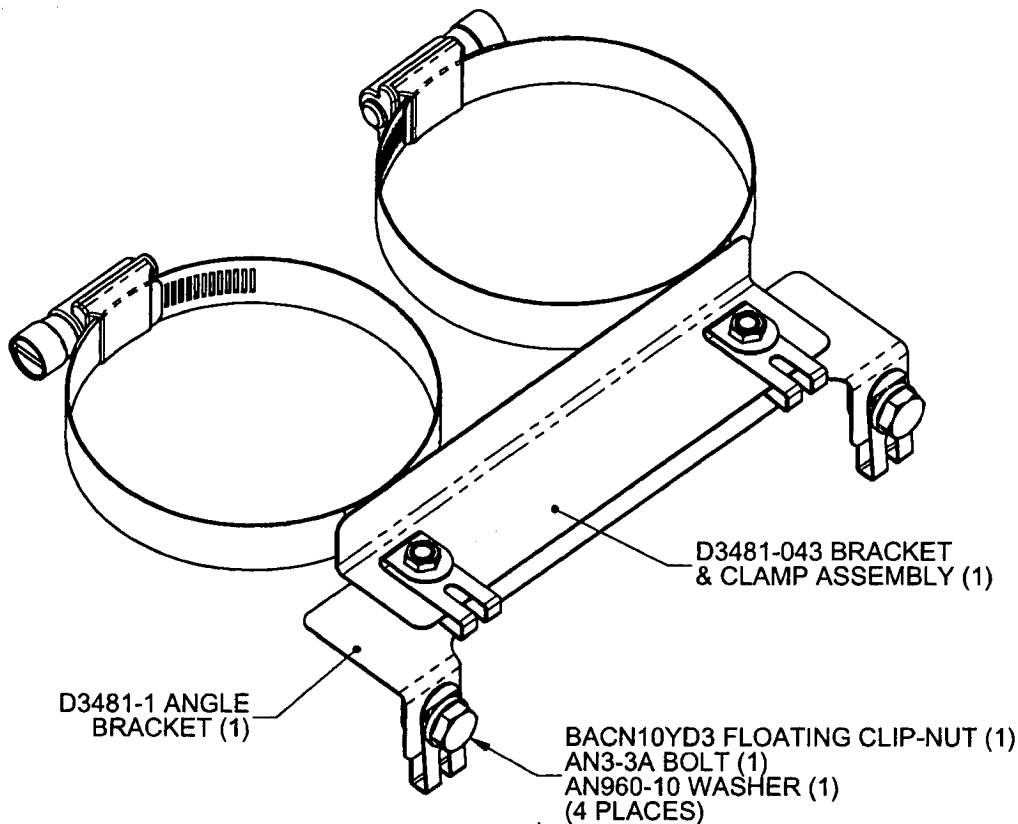
NOTE: Date & initial all entries





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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. A SHEET 1 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 2:3
A	06.01.23	NEW ISSUE	

[Signature] 06.04.03



D3481-041 SHUT-OFF VALVE BRACKET

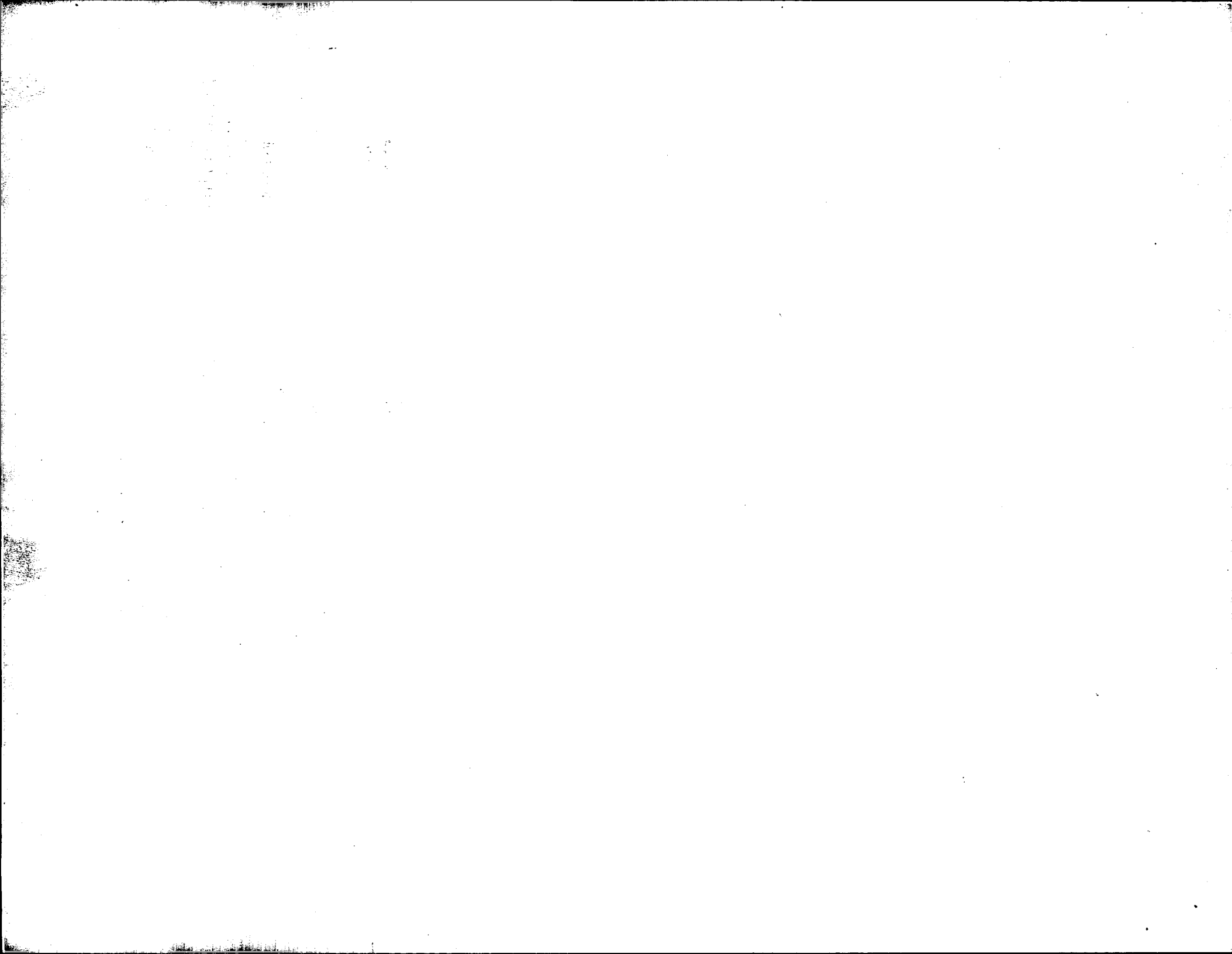
1) IDENTIFY WITH DART P/N D3481-041 USING FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	D3481-041	SHUT-OFF VALVE BRACKET
1	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-1	ANGLE BRACKET
4	AN3-3A	BOLT
4	AN960-10	WASHER
4	BACN10YD3	FLOATING CLIP-NUT

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NO. *34407*

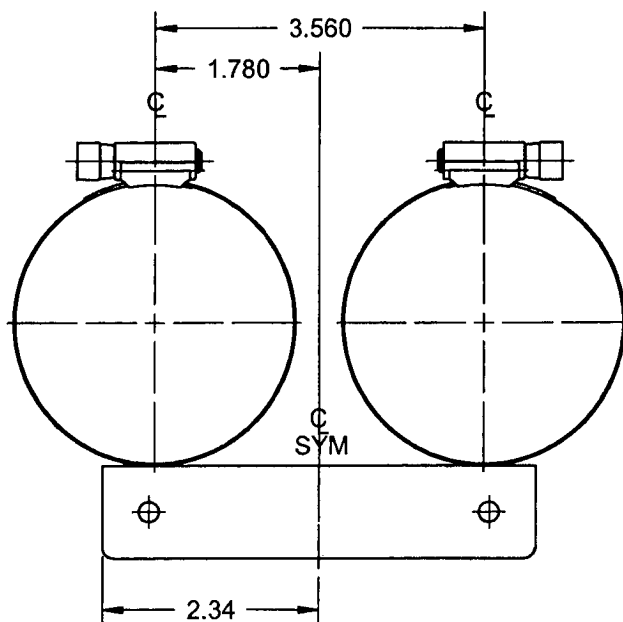
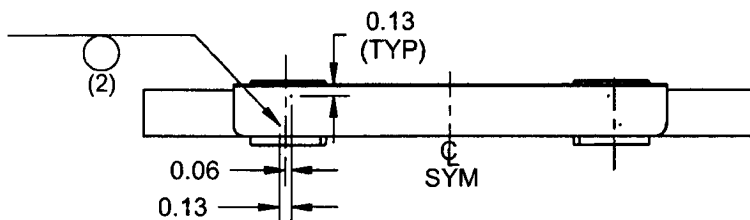
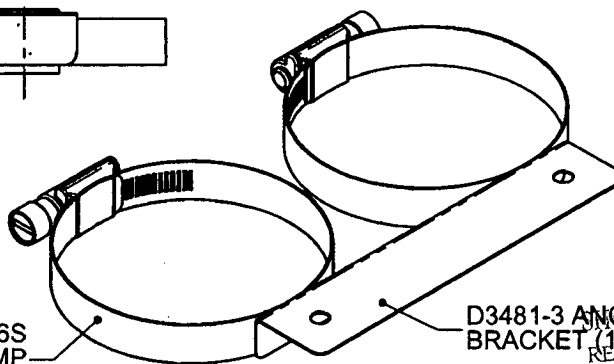
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DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

*[Signature]* 06-04-03QS20056S
AERO-SEAL CLAMP
(2 PLACES)D3481-3 ANGLE COPY
BRACKET (1)RETURN TO
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WORK ORDER
NO. *34407***D3481-043 BRACKET & CLAMP ASSEMBLY****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

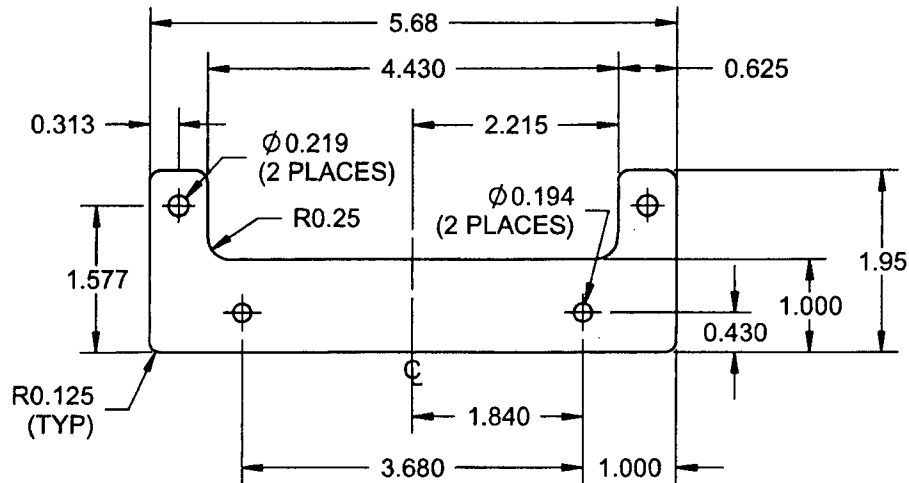
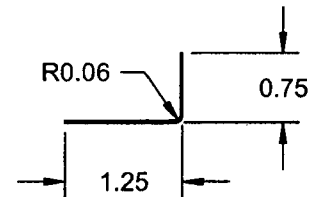
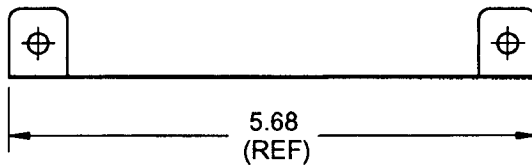
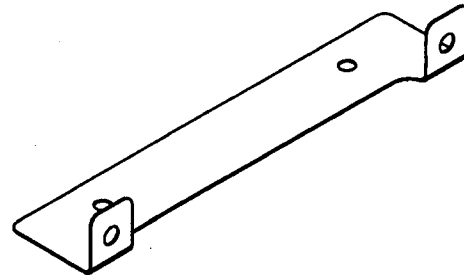
QTY -041	P/N	DESCRIPTION
X	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-3	ANGLE BRACKET
2	QS20056S	AERO-SEAL CLAMP

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DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

**D3481-1F FLAT PATTERN****D3481-1 ANGLE BRACKET***[Handwritten signature]* 06.04.03**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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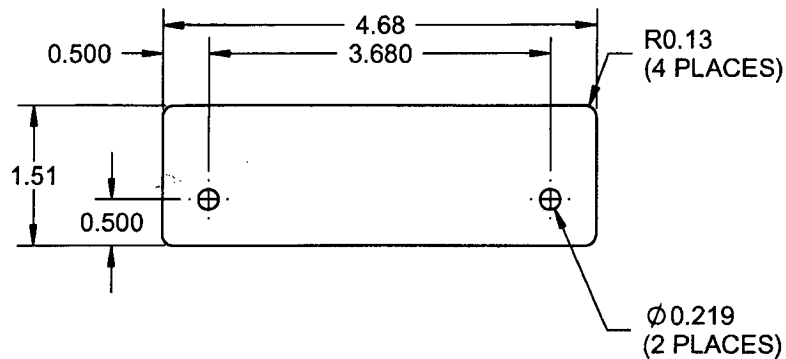
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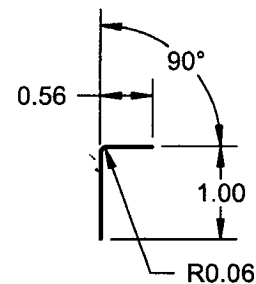
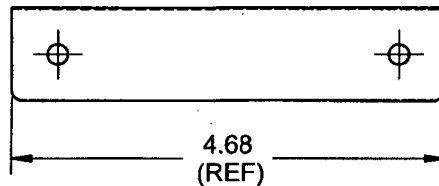


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DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

ff 06.04.03



D3481-3F FLAT PATTERN



D3481-3 ANGLE BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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